

Work Order ID 70569

Monday, June 13, 2011 10:22:07 AM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 6-13-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4030

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

6/11/07/05 @

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

6/11/07/05 @

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

6/11/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70569

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Page 2

Item ID: D4030-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Assembly (350)

Start Date: 6/10/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP 70568

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/5

ME
11-07-05

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Picklist Print

Monday, June 13, 2011 10:22:13 AM

Page 1

Work Order ID: 70569

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)







Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																		
D2530  Handle Weldment		Manufactured	No			100	Each	17.0000	1	1		6/11/07/05																			
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST506</td><td>7</td><td></td></tr><tr><td>68363</td><td>1</td><td></td></tr><tr><td>69907</td><td>6</td><td></td></tr><tr><td>ST508</td><td>10</td><td></td></tr><tr><td>69318</td><td>10</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST506	7		68363	1		69907	6		ST508	10		69318	10	
Location	Loc Qty	Loc Code																													
ST506	7																														
68363	1																														
69907	6																														
ST508	10																														
69318	10																														
D2535  Spring		Manufactured	No			100	Each	53.0000	2	2		6/11/07/05																			
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST504</td><td>53</td><td></td></tr><tr><td>66764</td><td>25</td><td></td></tr><tr><td>69495</td><td>28</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST504	53		66764	25		69495	28							
Location	Loc Qty	Loc Code																													
ST504	53																														
66764	25																														
69495	28																														
D2537  Bushing		Manufactured	No			100	Each	44.0000	2	2		6/11/07/05																			
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST504</td><td>44</td><td></td></tr><tr><td>66972</td><td>14</td><td></td></tr><tr><td>69894</td><td>30</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST504	44		66972	14		69894	30							
Location	Loc Qty	Loc Code																													
ST504	44																														
66972	14																														
69894	30																														
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1		6/11/07/05																			

B71213 (P)

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 70569

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3914-041 Manufactured No

100 Each 0.0000

1

1



Long Basket Lid Assembly (350)

B70571



EP 11/07/05

D3917-3 Manufactured No

100 Each 69.0000

6

6



Washer



EP 11/07/05

Location

Loc Qty

Loc Code

ST092

69

69513

23

69896

46

6

D3953-3 Manufactured No

100 Each 9.0000

2

2



Gas Spring Stud, Lid



EP 11/07/05

Location

Loc Qty

Loc Code

ST096

9

69611

9

B69974

D3953-7 Manufactured No

100 Each 39.0000

2

2



Spring Spacer



EP 11/07/05

Location

Loc Qty

Loc Code

ST096

39

65053

4

68464

2

69975

33

2

D3953-9 Manufactured No

100 Each 59.0000

2

2



Gas Spring Washer



EP 11/07/05

Location

Loc Qty

Loc Code

ST096

59

69025

5

69973

54

2

Monday, June 13, 2011 10:22:14 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 70569

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-14A Purchased No 100 Each 148.0000 4 4
Bolt

Location	Loc Qty	Loc Code
ST352	148	
117688	48	
117872	100	

4 4
4
4

AN3-16A Purchased No 100 Each 133.0000 2 2
Bolt

Location	Loc Qty	Loc Code
ST352	133	
116419	33	
117441	100	

2 2
2
2

AN5-17A Purchased No 100 Each 126.0000 4 4
Bolt

Location	Loc Qty	Loc Code
ST339	126	
117313	26	
117619	50	
117872	50	

4 4
4
4

AN4-12 Purchased No 100 Each 68.0000 3 3
Bolt

Location	Loc Qty	Loc Code
ST357	68	
116786	8	
117514	60	

3 3
3
3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 5

Work Order ID: 70569

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN310-4

 NUT

Purchased No

100 Each

35.0000

3

3



EP 11/07/05

Location

Loc Qty

Loc Code

ST324

35


117795

15

117872

20

3

AN310C4

 Nut

Purchased No

100 Each

53.0000

2

2



EP 11/07/05

Location

Loc Qty

Loc Code

ST324

53

116741

4

117395

49

2

MS21042L3

 Nut

Purchased No

100 Each

2,290.000

6

6



EP 11/07/05

Location

Loc Qty

Loc Code

ST300

2290

116391

9

116549

581

117441

800

117601

400

117885

500

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 6

Work Order ID: 70569

Parent Item: D4030-041


Parent Item Name: Long Basket Assembly (350)

Start Date: 6/10/2011

Required Date: 6/22/2011


Start Qty: 1.00

Required Qty: 1.00

MS21042L5 Purchased No 100 Each 1,056.000 4

 Nut


Location	Loc Qty	Loc Code
ST300	1056	
116105	96	
116548	260	
117441	500	
117591	100	
117611	100	

4
 EPB 11/07/05

MS24665-151 Purchased No 100 Each 472.0000 3

 Cotter Pin


Location	Loc Qty	Loc Code
ST309	472	
17566	472	

3
 EPB 11/07/05

MS24665-300 Purchased No 100 Each 76.0000 2

 Cotter Pin

Location	Loc Qty	Loc Code
ST309	76	
116823	76	

2
 EPB 11/07/05

NAS1149F0432P Purchased No 100 Each 278.0000 6

 Washer

Location	Loc Qty	Loc Code
ST275	278	
117291	278	

6
 EPB 11/07/05

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Monday, June 13, 2011 10:22:15 AM

Page 7

Work Order ID: 70569

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P Purchased No
Washer

100 Each 236.0000 4 4

Location Loc Qty Loc Code

ST275 36

114576 36

ST297 200

117735 200

NAS1149F0332P Purchased No
WASHER

100 Each 224.0000 8 8

Location Loc Qty Loc Code

ST275 224

117735 200

17317 24

NAS1149C0432R Purchased No
Washer

100 Each 5,554.000 2 2

Location Loc Qty Loc Code

ST297 5554

116900 554

117291 5000

D4086-200 Manufactured No
Placard, Max Load

100 Each 3.0000 1 1

Location Loc Qty Loc Code

ST122 3

66276 3

Monday, June 13, 2011 10:22:15 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

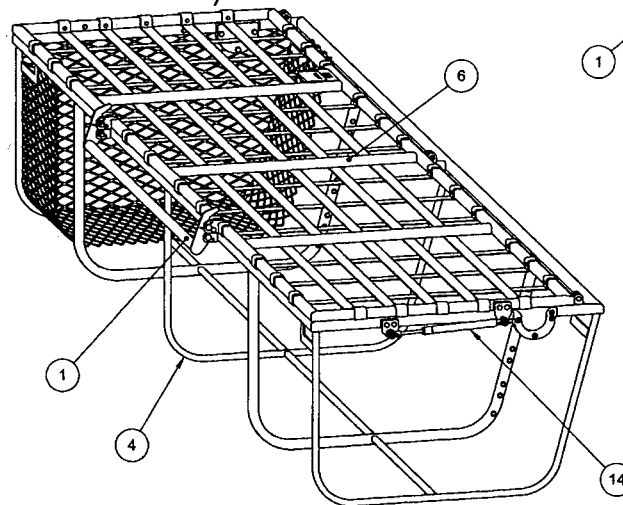
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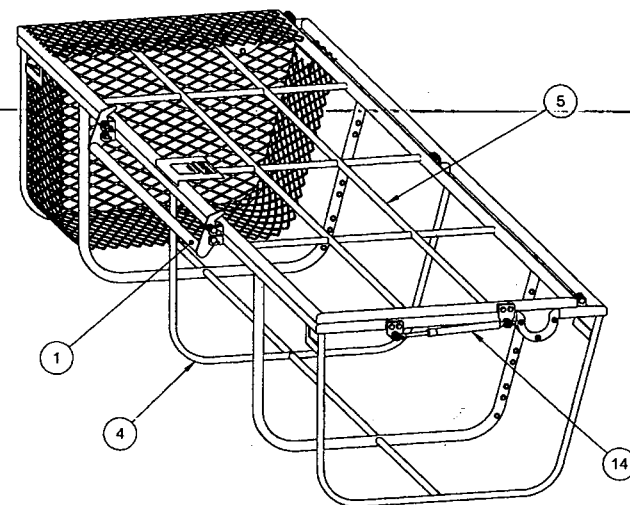
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70569

P 11-08-13



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12
ECN 10-596

- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
 -043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (BB-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>JES</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D4030		REV. C	
TITLE LONG BASKET ASSY (350)		SCALE	
DATE 10.07.23		NTS	

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W/O:		WORK ORDER CHANGES					
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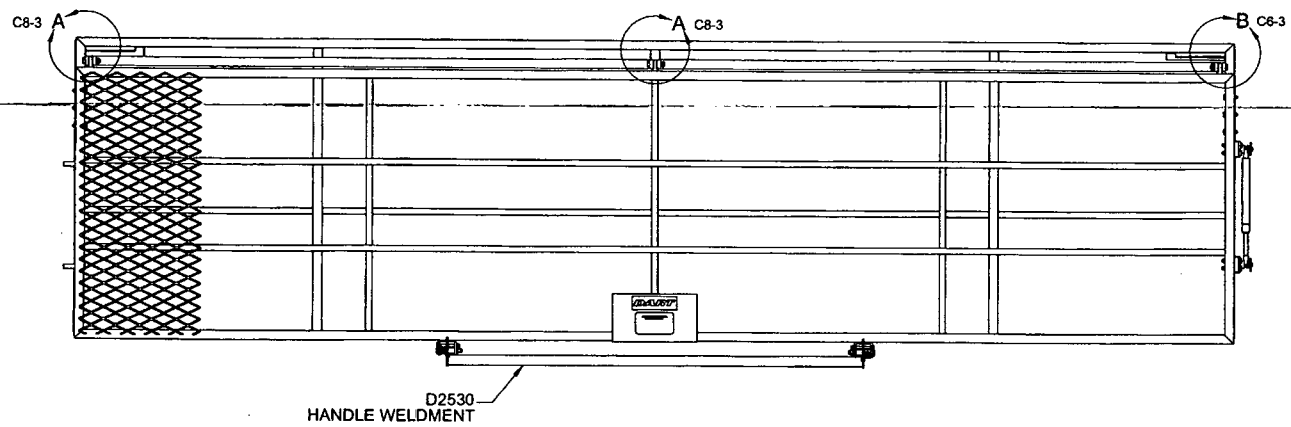
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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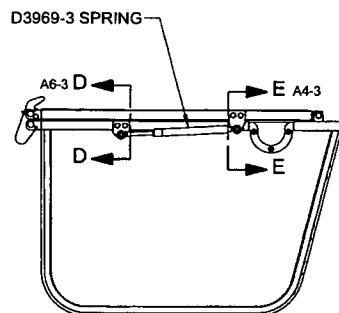
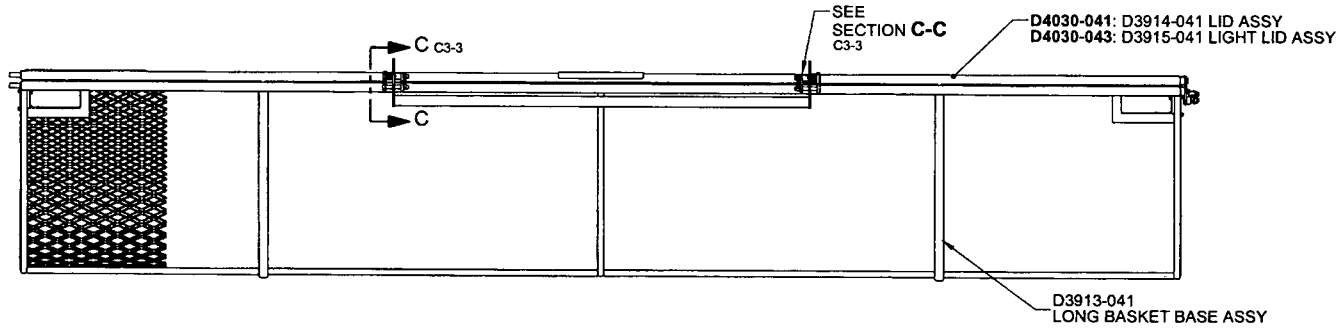
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



U1070860



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	SEP 1981	D4030	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET ASSY (350) NTS.	
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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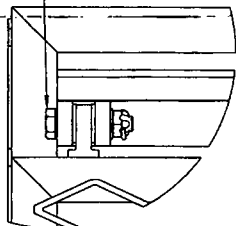
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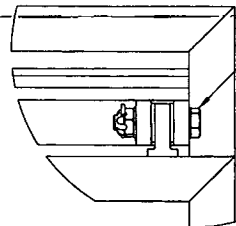
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



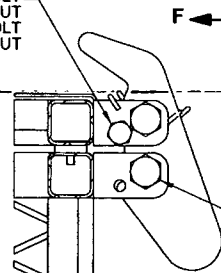
DETAIL A D8-2
D5-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT

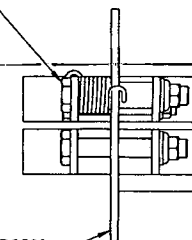


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350) NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

C2507 115